

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009759**Date Inspected:** 08-Oct-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Yumin and Li Jia**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Joe Alaniz was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

OBG Assembly Yard

This QA Inspector performed MT of approximately 15% of areas previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member(s) is/are identified as OBG 2AE Longitudinal Diaphragm. The weld designations reviewed are as follows:

1. LD017-007-001

1AAW + 1AW

FCAW build up welding performed on deck plate stiffeners located above bottom plate.

Welder is identified as Mr. Chen Zhenghua (220067). ZPMC QC is identified as Xu Yumin.

The welding variables recorded by QC appeared to comply with WPS-345-FCAW-4G (4F)-Repair and CWR778.

FCAW build up welding performed on deck plate stiffeners located above bottom plate.

Welder is identified as Mr. Li Guimin (220069). ZPMC QC is identified as Xu Yumin.

The welding variables recorded by QC appeared to comply with WPS-345-FCAW-4G (4F)-Repair and CWR778.

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FCAW build up welding performed on deck plate stiffeners located above bottom plate.
Welder is identified as Mr. Cao Caijun (220064). ZPMC QC is identified as Xu Yumin.
The welding variables recorded by QC appeared to comply with WPS-345-FCAW-4G (4F)-Repair and CWR778.

For further information of weld buildup work in progress of above noted stiffeners, please refer to repair procedure CWR778 (Rev 1) and RFI 1904.

2AAW + 2AW

FCAW repair welding of weld joint 065 located on SSD34-PP8.5.
Welder is identified as Mr. Zhou Pan (220063). ZPMC QC is identified as Xu Yumin.
The welding variables recorded by QC appeared to comply with WPS-345-FCAW-3G (3F)-FCM-Repair and repair procedure WRR7477.

2AAW + 2AW

SMAW repair welding of weld joint 009 located on OBW1.
Welder is identified as Mr. Zhou Pan (048659). ZPMC QC is identified as Xu Yumin.
The welding variables recorded by QC appeared to comply with WPS-345-SMAW-3G (3F)-FCM-Repair and repair procedure WRR7477.

1AAW + 1AW

SMAW welding of weld joints 051 and 052 located on OBE1.
Welder is identified as Mr. Li Bo (048659). ZPMC QC is identified as Xu Yumin.
The welding variables recorded by QC appeared to comply with WPS-B-T-2114-FCM-1.

SMAW welding of weld joints 053 and 054 located on OBE1.
Welder is identified as Mr. Li Bo (048659). ZPMC QC is identified as Xu Yumin.
The welding variables recorded by QC appeared to comply with WPS-B-T-2113-FCM-1.

NDT Observation

This QA Inspector observed ZPMC Magnetic Particle (MT) Technician performing MT on various locations in the trial assembly yard. Locations are as followed:

1. Drip plates weld joint at panel point 12.5 and 12 located on the crossbeam side of segment 1BW.
2. Drip plates at weld splice in between 2AW and 2BW located on the crossbeam side of segment.
3. Excavation areas on weld joint OBW1A located on the counter weight side of segment 1AW to 1BW.

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Miscellaneous Work In Progress

QA Inspector observed ZPMC's personnel performing various job functions in the trial assembly yard. Locations and description of work are as followed:

1. Grit blasting of various internal areas in segment 2E.
2. UT reject excavation on 2AW floor beam flange weld joint SSD11-PP15-002 located on counter weight side of segment.

Note:

Due to China National Holiday, work was limited in the OBG Trail Assembly Yard on today's work shift.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (134-8257-0045), who represents the Office of Structural Materials for your project.

Inspected By:	Alaniz,Joe	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
